IN THE CLAIMS

Please amend the claims to read as follows:

1. (Currently Amended) A method for deep-rolling radii or fillets at the transition between the bearing journals and the adjacent flange of a bearing point of a crankshaft with the aid of deep-rolling cylinder that are pressed into the radius or the fillet of the transition with a deep-rolling force while the crankshaft is ~~turned~~ rotated until a predetermined roll-down depth is reached, ~~characterized in that the transition~~ comprising

- ~~is initially deep-rolled~~ initially deep-rolling the transition with a first deep-rolling cylinder, the radius of which has an osculating ratio between 1 and 0.85 referred to the radius of the transition or the fillet, ~~namely with~~ where the roll-down depth to be achieved with the first deep-rolling cylinder is approximately 0.2 mm ~~a first deep rolling force that produces a maximum internal compressive stress in the transition at a depth between 1 and 2 mm below the deep rolled surface~~ below the surface of the radius of the transition or the fillet, and
- subsequently rerolling the same transition with a second deep-rolling cylinder that has a smaller radius than the first deep-rolling cylinder, ~~namely with~~ the roll-down depth to be additionally achieved with the second deep-rolling cylinder being approximately 0.05 mm ~~a second deep rolling force of such magnitude that the second deep rolling cylinder causes a further plastic deformation on~~ below the deep-rolled surface of the transition in addition to the plastic deformation achieved with the first deep-rolling cylinder.

2. (Cancelled).